

Work Order ID 58307

May 3, 2010 11:19:49 AM



Page 1

Item ID: D4035-047

Accept



Setup Start



Revision ID:

Stop



Item Name: Lid Rib Assembly, Aft (Light)

Start Date: 03/05/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 13/05/2010 Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

[Signature]

Date: 10-5-03 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4035

A

100

Weld per dwg A/R Aluminum rod Batch: M112860.00



Large Fab

Large Fab

Memo

0.00

- 1- Cut D4035-7 as per dwg D4035
- 2- Drill hole using DT9563 and chamfer holes as per dwg D4035
- 3- remove identification marks and deburr
- 4- Weld bushing in rib and grind weld flush as per dwg D4035

10-05-05

(3)

SAD 10-05-05

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Quality Control

Memo

0.00

(3) PD 10-05-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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May 3, 2010 11:19:49 AM



Page 2

Item ID:	D4035-047	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Lid Rib Assembly, Aft (Light)					
Start Date:	03/05/2010	Start Qty:	3.00	Cust Item ID:		
Required Date:	13/05/2010	Req'd Qty:	3.00	Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	8.10.05/05			(+3)			
130 Packaging Packaging	Identify as per dwg & Stock Location: <u>W/A</u> Memo	0.00 0.00	R 10.05.05			3	φ		
140 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							10/05/06 BJ 10-5-05 (3)

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Picklist Print

May 3, 2010 11:19:53 AM

Page 1

Work Order ID: 58307

Parent Item: D4035-047

Parent Item Name: Lid Rib Assembly, Aft (Light)

Comments: IPP RevA: new issue DD 10.01.25 verified by:EC
per dwg revA 10.03.15 verified by:EC

IPP Rev:B as

Start Date: 03/05/2010

Required Date: 13/05/2010

Start Qty: 3.00

Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D4035-11		Manufactured	No			100	Each	4.0000	2			
Bushing												

M6061T6TS0.750W.06
2

Purchased No

6061-T6 SQ Tube .75 x .75 x .062W

Location	Loc Qty	Loc Code
ST109	358376	
56958		
	100	f
	77.6752	1.875

Location	Loc Qty	Loc Code
MAT06	77.6752	
103069	38.0526	
104422	15.5263	
16441	4.07	
9671	20.0263	

M114573 → 1.875 x 3 = 5.625

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

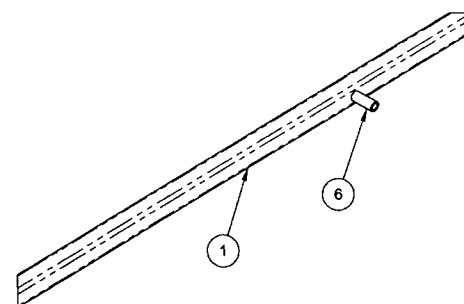
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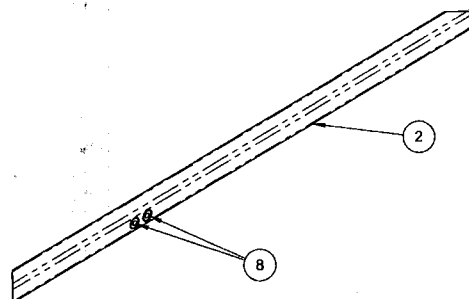
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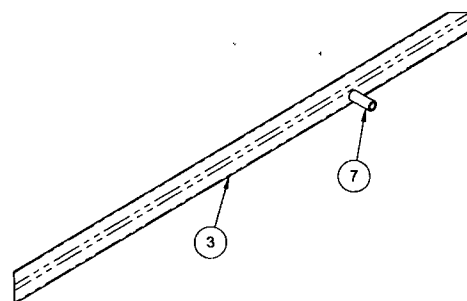
ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
	X				D4035-041	LID RIB ASSY, FWD
		X			D4035-043	LID RIB ASSY, AFT
			X		D4035-045	LID RIB ASSY, FWD (LIGHT)
				X	D4035-047	LID RIB ASSY, AFT (LIGHT)
1	1				D4035-1	RIB
2		1			D4035-3	RIB
3			1		D4035-5	RIB
4				1	D4035-7	RIB
5				2	D4035-11	BUSHING
6	1				D2327-3	SPACER BUSHING
7			1		D2953-175	SPACER
8		2			D4021-9	BUSHING



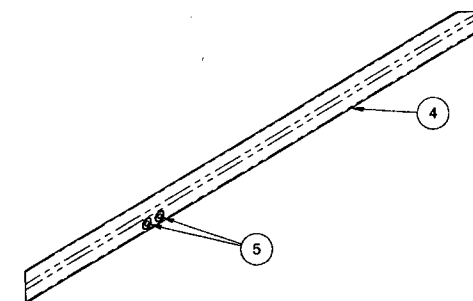
D4035-041 BASKET LID RIB ASSY, FWD



D4035-043 BASKET LID RIB ASSY, AFT



D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)



D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)

RELEASED
2010-03-12

58307

A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH	DRAWING NO.	REV. A
CHECKED		D4035	SHEET 1 OF 5
MFG. APPR.		TITLE	SCALE
APPROVED		BASKET LID RIB ASSY	NTS
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DATE	10.03.04		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

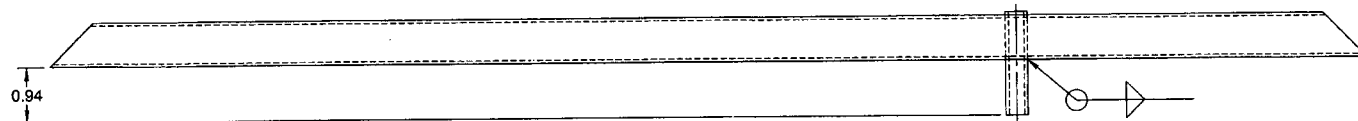
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D



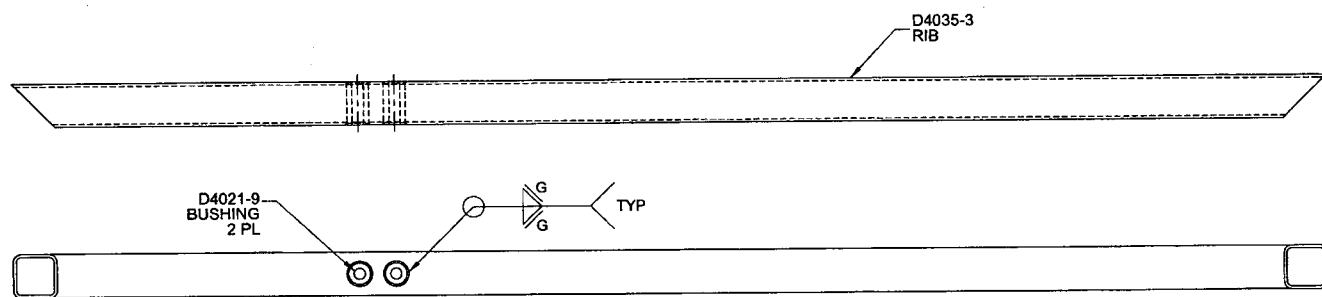
D4035-1
RIB

D2327-3
SPACER BUSHING

D4035-041 BASKET LID RIB ASSY. FWD

C

B



D4021-9
BUSHING
2 PL

D4035-3
RIB



D4035-043 BASKET LID RIB ASSY. AFT

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.83 lbs
- 8) WELDING: PER DART QSI 004

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2010-03-12

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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4035	SHEET 2 OF 5
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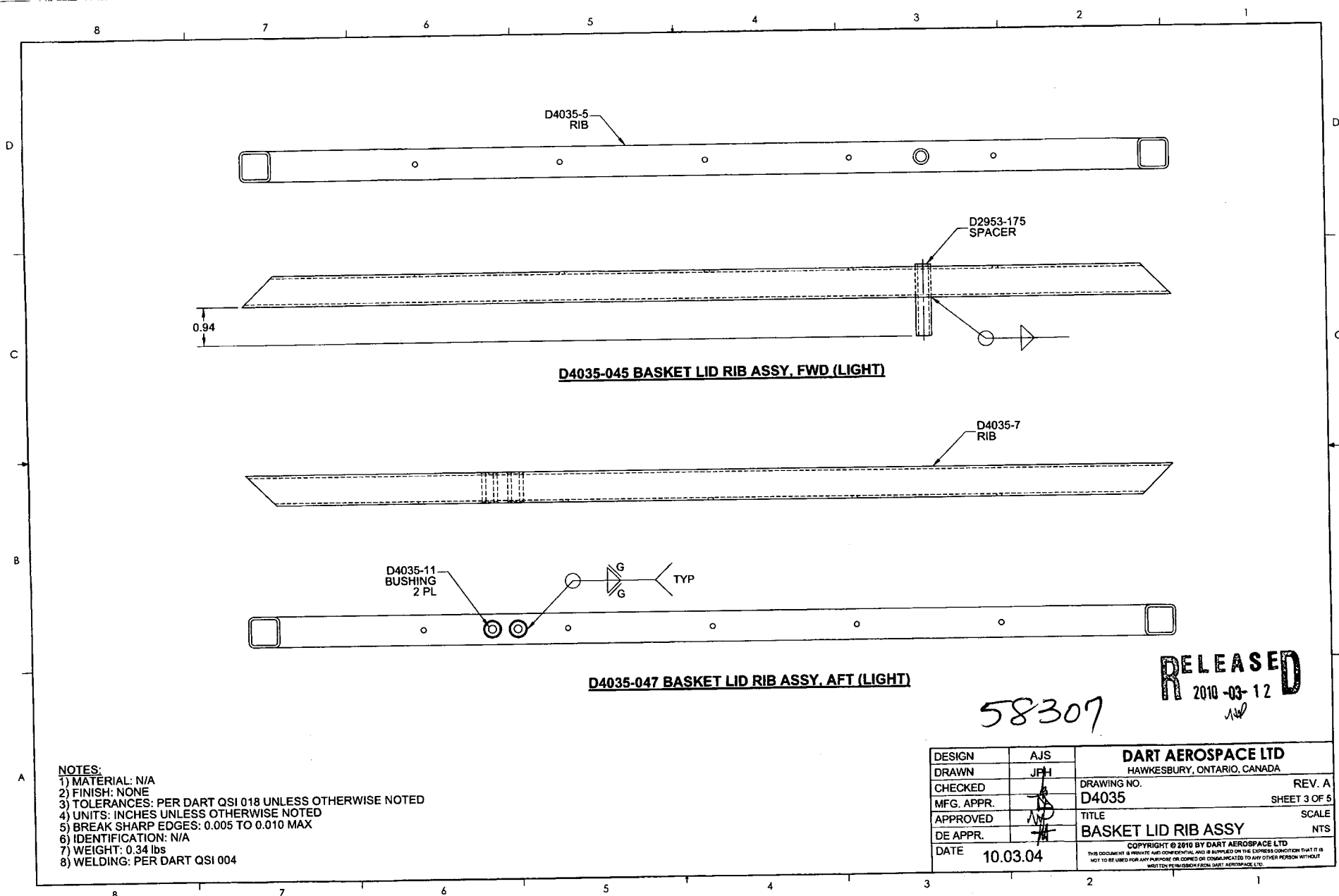
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.34 lbs
 - 8) WELDING: PER DART QSI 004

D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)

D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)

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2010-03-12
MAD

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DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. A
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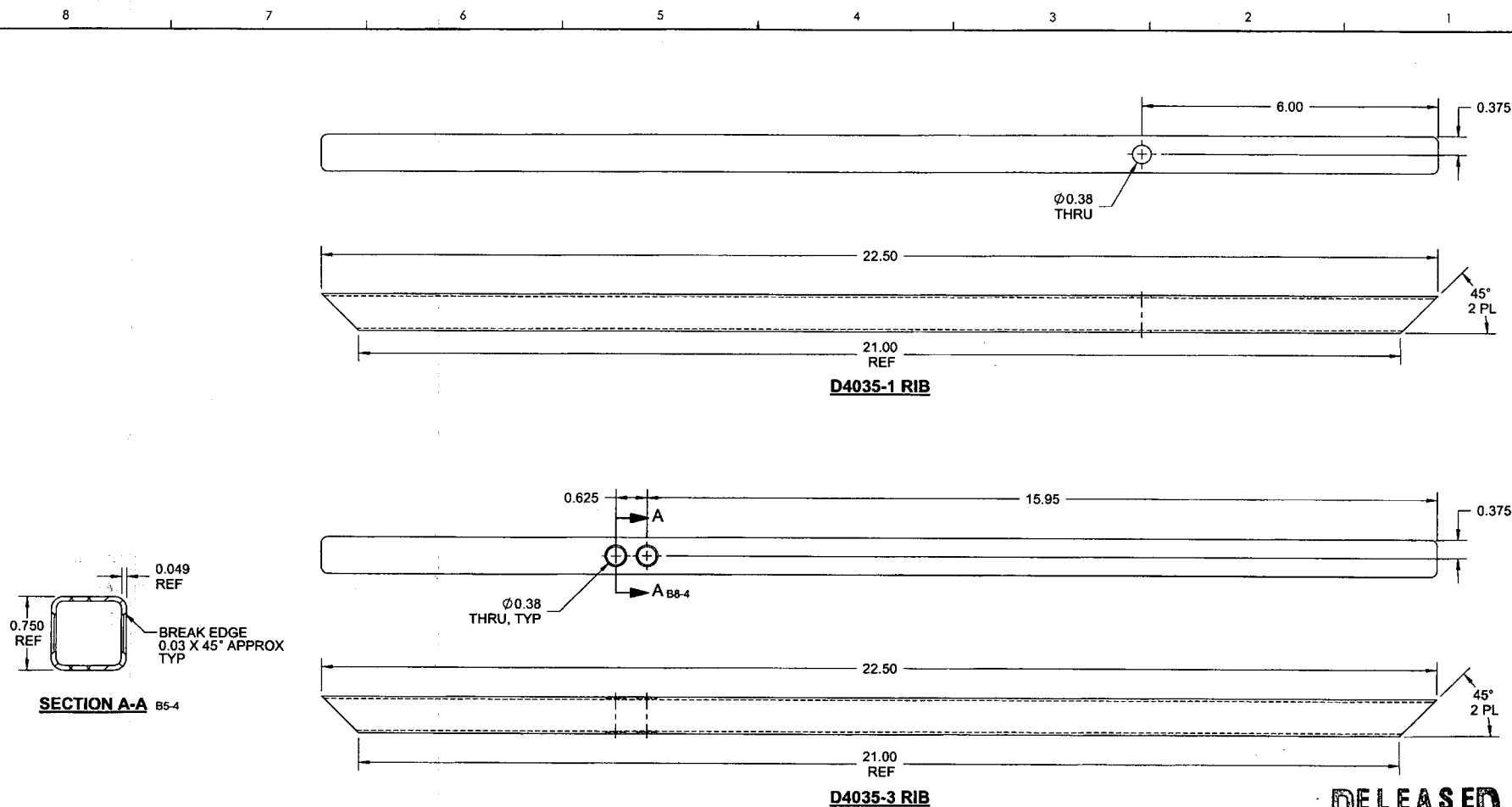
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NOTE: Date & initial all entries



NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
PER ASTM A554/A269 MILL FINISH
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP, EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.80 lbs

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4035	REV. A SHEET 4 OF 5
MFG. APPR.	<i>[Signature]</i>	TITLE BASKET LID RIB ASSY	SCALE NTS
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2010-03-12
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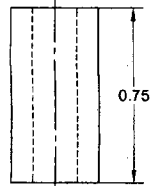
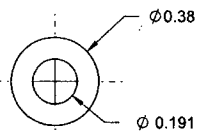
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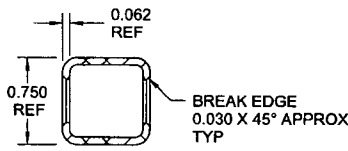
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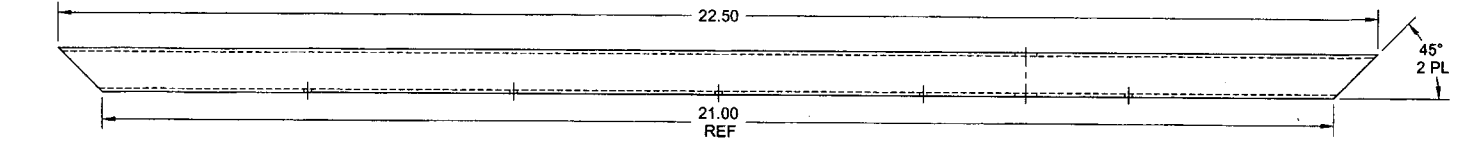
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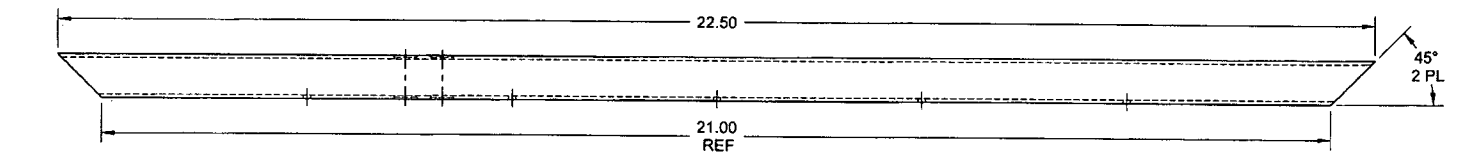
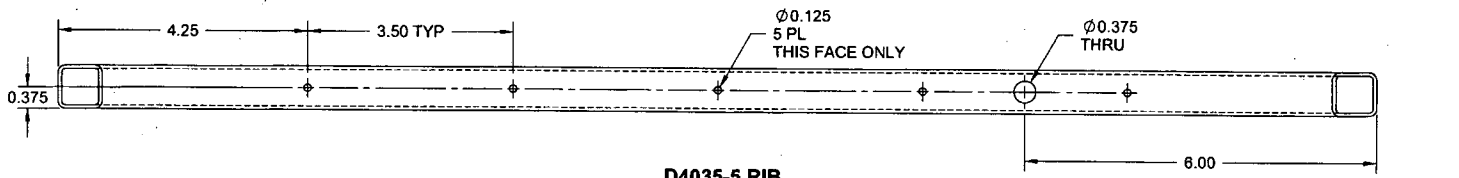
D4035-11 BUSHING



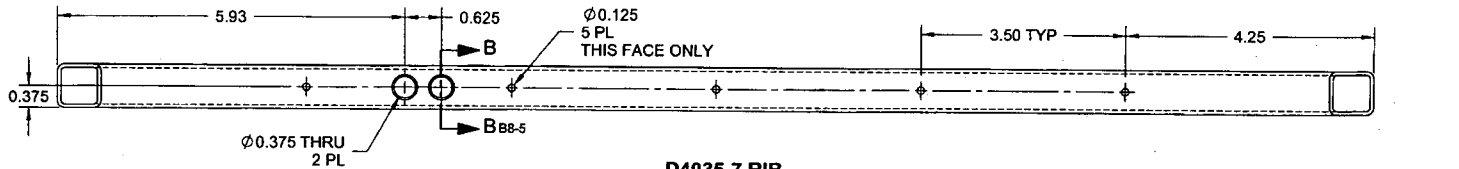
SECTION B-B B5-5



D4035-5 RIB



D4035-7 RIB



NOTES:

- 1) MATERIAL: -5 & -7: 6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) SQUARE TUBING
PER AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4115 / 4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC. M6061T6TS0.750W.062
-11: 6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4115 / 4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC. M6061T6R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: -5 & -7: 0.33 lbs; -11: 0.01 lbs

RELEASED
2010-03-12
MD

58307

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4035	SHEET 5 OF 5
APPROVED		TITLE	SCALE
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8 7 6 5 4 3 2 1

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